

# Work Order ID 78140

December-29-11 10:35:07 AM

**\*78140\***

Page 1

Item ID: D2661-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH Fwd Aft Out 206  
 Start Date: 29/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/29 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100  
**\*100\***  
 HAAS 1  
 HAAS CNC vertical machine #1  
 HAAS CNC VERTICAL MACHINING #1  
 Memo  
 Program part number and batch number  
 MACHINE AS PER DWG AND FOLIO FB071  
 FOLIO REV: AA  
 DWG REV: E  
 0.00  
 10 0

110  
**\*110\***  
 Mill Conv  
 Conventional Milling Machine  
 CONVENTIONAL MILLING MACHINE  
 Memo  
 Machine Keyway and inspect per attached dimension sheet  
 0.00  
 10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Item ID: D2661-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Item Name: Saddle, RH Fwd Aft Out 206  
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 Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SL/BA	12/01/14		10	0		
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	amk	12/01/19		10	0		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				10	0		10X4M-12/04/19

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**Dart Aerospace Ltd**

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# Picklist Print

December-29-11 10:35:10 AM

Page 1

Work Order ID: 78140

**\*78140\***

Parent Item: D2661-2

**\*D2661-2\***

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house  
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003

Manufactured

No

100

Each

92.0000

1

10

**\*D6101-003\***

\*\*

Da 12/01/14

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

16

73775

2

73780

7

MAT042

-7

MAT044

83

73769

1

→ 76837

82

10.0

# Dart Aerospace Ltd

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 78140
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.120	.120	.120	.120	.120
H	0.210	0.230		.222	.222	.223	.222	.222
I	0.615	0.685		.685	.685	.685	.685	.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.326	1.325	1.326	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.136	1.136	1.136	1.136	1.135
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.125	.124	.125	.125	.125
Q	0.240	0.260		.250	.249	.251	.250	.250
R	0.677	0.697		.689	.688	.686	.688	.688
S	0.100	0.140		.120	.119	.122	.120	.122
T	1.565	1.585		1.576	1.576	1.576	1.576	1.575
U	0.540	0.560		.550	.550	.549	.550	.550
V	0.912	0.932		.921	.922	.921	.920	.919
W	0.787	0.807		.796	.797	.796	.798	.799
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.501	.499	.500	.501
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.502	.502	.502	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.109	.110	.110	.110	.110
AI								

12-01-B

OK 12/01/19

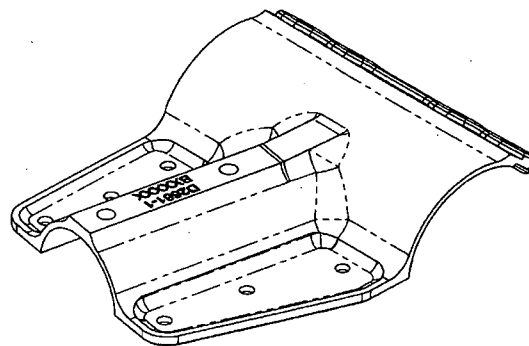
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	48140
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 2</b>	

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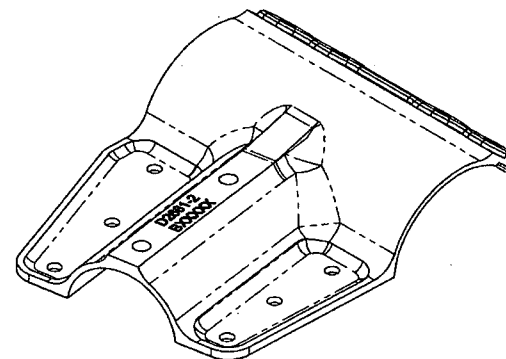
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D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.120	.120	0.120	0.122	0.123
H	0.210	0.230		.222	.223	0.223	0.223	0.223
I	0.615	0.685		.685	.685	.685	.685	.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
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L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.135	1.135	1.135	1.135
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.125	.125	0.125	0.125	0.125
Q	0.240	0.260		.250	.251	0.250	0.250	0.250
R	0.677	0.697		.688	0.687	0.688	0.688	0.687
S	0.100	0.140		.121	.120	0.124	0.125	0.125
T	1.565	1.585		1.575	1.575	1.577	1.578	1.5765
U	0.540	0.560		.549	.550	0.550	0.550	0.550
V	0.912	0.932		.921	.923	0.922	0.922	0.921
W	0.787	0.807		.797	.796	0.797	0.797	0.798
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
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AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
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AD	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.237	0.237	0.237	0.237	0.237
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AH	0.100	0.120		0.110	0.110	0.109	0.110	0.110
AI								

SL 12-01-13 / A-12 12/01/14

OK 12/01/19



**D2661-1 SADDLE, OUTSIDE, LH**



**D2661-2 SADDLE, OUTSIDE, RH**

**RELEASED**  
2011-11-16

SHOWN IN  
REVISION  
ENCLOSURE  
UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK ORDER

NO. 78140 M.C.J.  
11/12/29

REV.	DESCRIPTION	BY	DATE																												
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31																												
D	R0.188 WAS R0.30; Ø0.318 WAS Ø0.313	CB	06.11.08																												
C	INCORPORATE DEO 9122, 9102, 9085	CB	06.05.29																												
B	ANGLE AND NOTES ADDED	KE	97.07.11																												
A	NEW ISSUE	DS	07.03.25																												
<table border="1"> <tr> <td>DESIGN</td> <td>GP</td> <td colspan="2"><b>DART AEROSPACE USA, INC.</b></td> </tr> <tr> <td>DRAWN</td> <td>GP</td> <td colspan="2">KENT, WA</td> </tr> <tr> <td>CHECKED</td> <td>ASS</td> <td>DRAWING NO.</td> <td>REV. E</td> </tr> <tr> <td>MFG. APPR.</td> <td>MA</td> <td>D2661</td> <td>SHEET 1 OF 5</td> </tr> <tr> <td>APPROVED</td> <td>MA</td> <td>TITLE</td> <td>SCALE</td> </tr> <tr> <td>DE APPR.</td> <td>MA</td> <td>SADDLE, OUTSIDE</td> <td>NTS</td> </tr> <tr> <td>DATE</td> <td>11.10.31</td> <td colspan="2"> <small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> </td> </tr> </table>				DESIGN	GP	<b>DART AEROSPACE USA, INC.</b>		DRAWN	GP	KENT, WA		CHECKED	ASS	DRAWING NO.	REV. E	MFG. APPR.	MA	D2661	SHEET 1 OF 5	APPROVED	MA	TITLE	SCALE	DE APPR.	MA	SADDLE, OUTSIDE	NTS	DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
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**NOTE:** Date & initial all entries

**D2661-1 SADDLE, OUTSIDE, LH**

1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25

7) WEIGHT: 0.79 lbs

**RELEASED**  
2011-11-16

DESIGN	DR	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DR	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	WJ	D2661	SHEET 2 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SADDLE, OUTSIDE	NTS
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DRAWN	<i>AS</i>	KENT, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2661	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE, OUTSIDE	NTS
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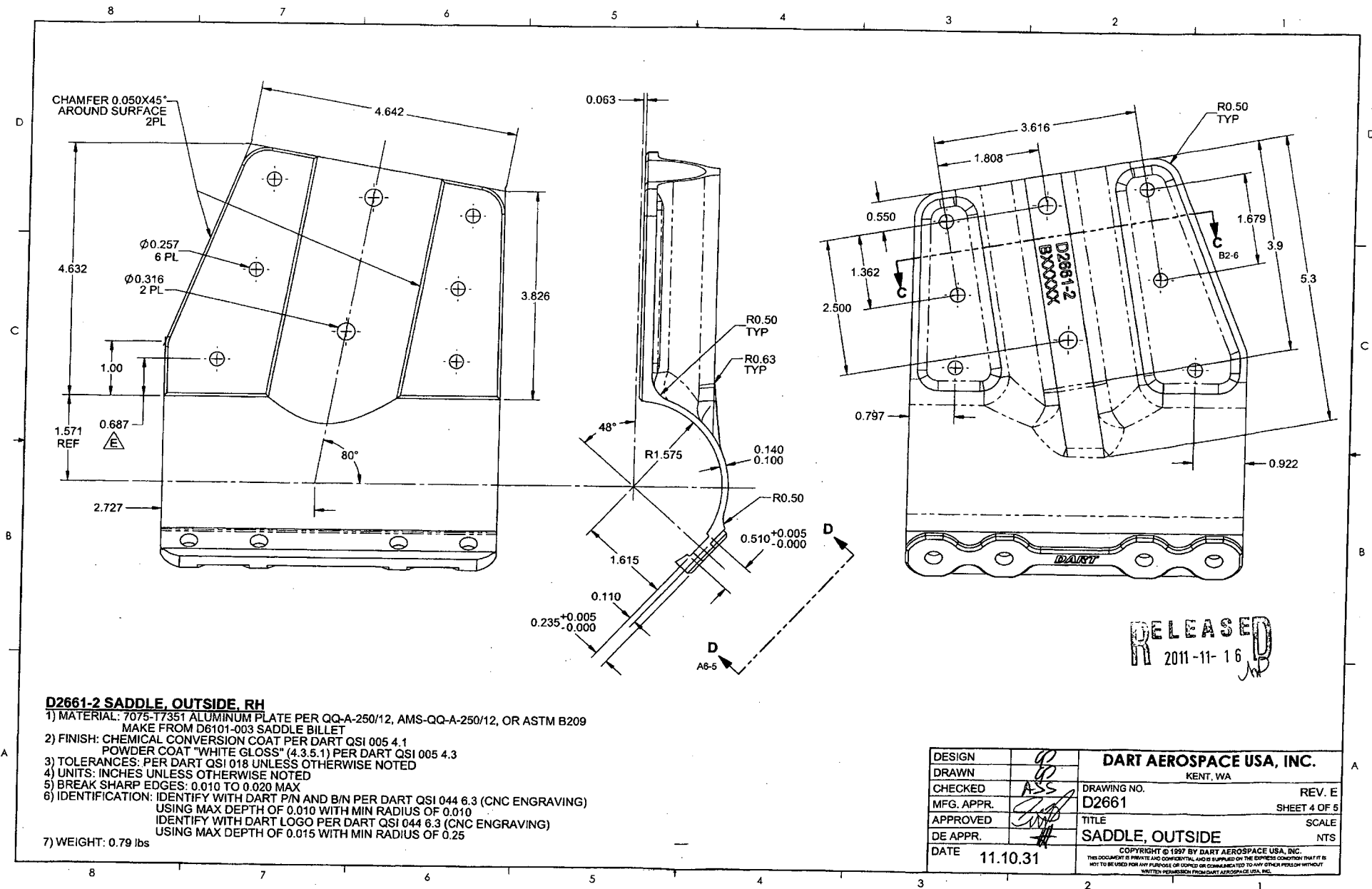
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APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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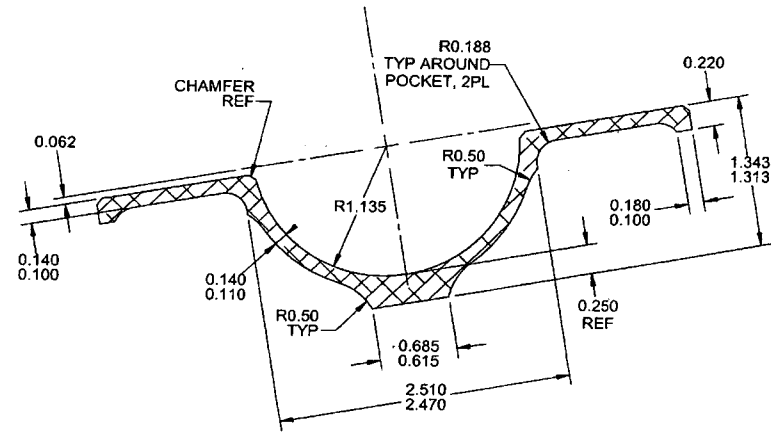
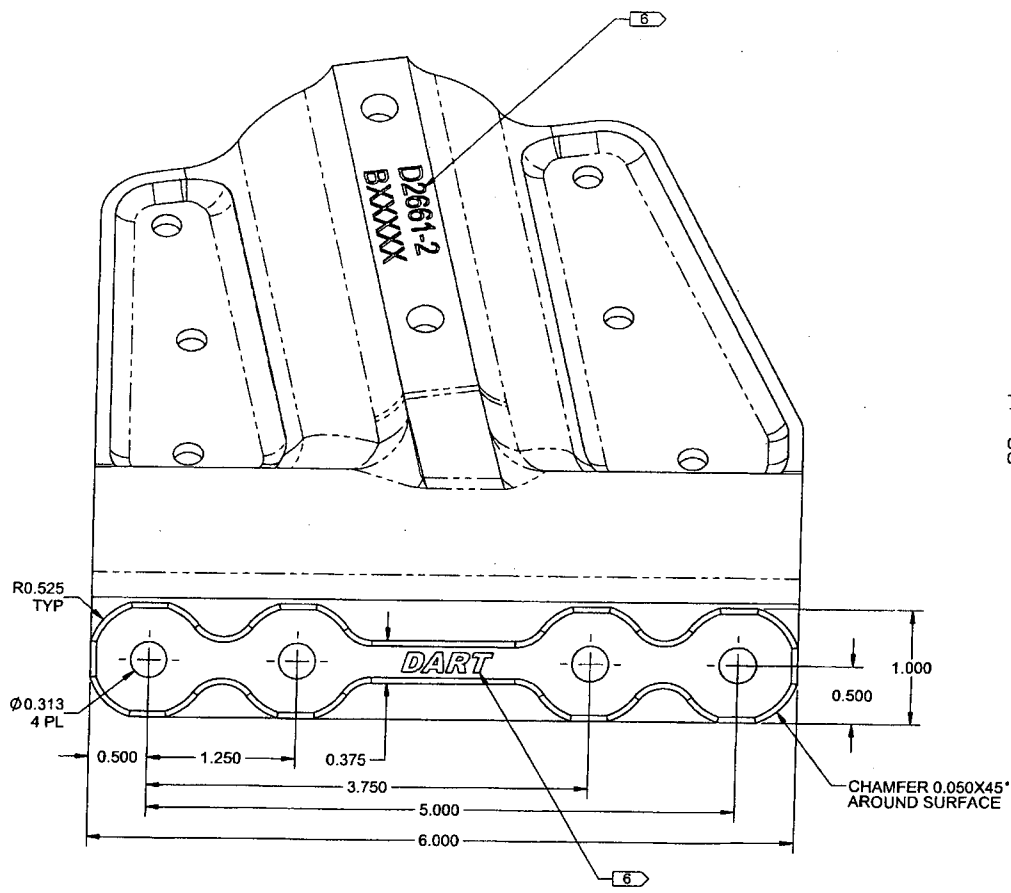
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MFG. APPR.	WJP	D2661	SHEET 5 OF 5
APPROVED	WJP	TITLE	SCALE
DE APPR.	WJP	SADDLE, OUTSIDE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes -No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries